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D205-633-015
Job Sheet 205025



Part No: D205-633-015 Job Qty: 2 pcs
Part Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH
Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 12/27/19 Job Tracking No:
Due Date: 1/20/20 Created By: Marie Lajeunesse
Type: SOLD Description:
Note: DWG REV C SHEET 17 IPP Rev:B 02.07.31 Re-Format KJ
Ship Via:

Bill of Materials

Job Routing

Op N°	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs	1/20/20	1/20/20	0.00	0.00	Packaging 1 - 1		DAS 80 DEC 30 2019 9-89
							Packaging 1 - 2		
							Packaging 1 - 3	✓	
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



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Container No: S246037
Part: D205-633-015
Job No: 205025
Serial No/Batch: S246037
Revision:
Inspector:
Exp Date:
Instructions: TC STC SH96-57 Issue 5 FAA STC SR005921

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					Packaging 1 - 37	
					QC 4 - 28	
					QC 4 - 58	
120 QC 4	2 pcs	1/20/20	0.00 0.00	QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
				QC 4 - 75		
				QC 4 - 78		
130 Packaging 3-1 - Stock - B4B	2 pcs	1/20/20	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
Packaging 3 - 35 - B4B						
Packaging 3 - 36 - B4B						
Packaging 3 - 37 - B4B						
131 DC - 1 - B4B	2 pcs	1/20/20	0.00 0.00	DC - 1 - B4B		
				DC - 2 - B4B		
140 QC 21 - FG	2 pcs	1/20/20	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - FG - 53		
Part Op 110 - (Pick Kit)						

DAS
78 JAN 1 0 2020
9-89

DAS
78 JAN 1 0 2020
9-89

DAS
21 JAN 1 0 2020
9-89

JAN 1 0 2020

FG607

Descriptions: 120 - (QC4- 100% inspect kits for completeness)
130 - (Identify as per dwg & Stock Location:) Identify and pack for shipping as per PPP D205-633-015
Location:
131 - (Document Control) Photocopy blue file & type labels per PPP D205-633-015 CHG002
140 - QC21- Final Inspection - Work Order Release)

(013694)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-10A	Bolt	2 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5144562 ✓
AN4-14A	Bolt	2 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5231789-1 ✓
AN4-5A	Bolt	2 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5155648 ✓
AN4-6A	Bolt	6 Ea (3 ea) ✓	110-Packaging 1 - Pick Kit	5228778 ✓
AN4-7A	Bolt	4 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5225336 ✓
AN4-14A	Eyebolt	2 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5172180 ✓
AN5-14A	Bolt	2 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5179150 ✓
D2022-101	Spacer	4 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5217132 ✓
D2022-103	Spacer	4 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5217258 ✓
D2562-005	Strut 29.00"	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5222461 143745(X) ✓
D2563	Step Weldment Assembly	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5226119 ✓
D2565-301	Strut	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5296246(X) 520848(X) ✓
D2565-303	Strut	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	52227(X) 5245334(X) ✓
D2565-305	Strut	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	520506(X) 529619(X) ✓
D2565-307	Strut	2 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	52017(X) 143749(X) ✓
D2565-309	Strut	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	529616 ✓
D3165-1	Support Arm	2 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	523234 ✓
MS21042L4	Nut	16 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	5228833 ✓
MS21042L5	Nut	4 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5241187 ✓
NAS1149D0463J	Washer	32 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	525595 ✓
NAS1149D0563J	Washer	6 Ea (3 ea) ✓	110-Packaging 1 - Pick Kit	5235266 ✓

QC.4 -

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN4-10A	2	23	0
	AN4-14A	2	472	0
	AN4-5A	2	118	0
	AN4-6A	6	444	0
	AN4-7A	4	201	0
	AN4-7A	2	26	0
	AN5-14A	2	56	0
	D2022-101	4	40	0
	D2022-103	4	63	0
	D2562-005	2	5	0
	D2563	2	10	0
	D2565-301	2	3	0
	D2565-303	2	1	0
	D2565-305	2	2	0
	D2565-307	2	4	0
	D2565-309	2	3	0
	D3165-1	2	0	0
	MS21042L4	16	2,938	0
	MS21042L5	4	525	0
	NAS1149D0463J	32	3,379	0
	NAS1149D0563J	6	1,087	0

Part Specifications

Specifications could not be found.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:	QTY Affected :		MRB (QS1042)							
Description Work Order Deviation				Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY							
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details:		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		Power Loss/Surge ☐ Follo/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
				Completed By							
				Lead hand / Supervisor							
				QC / QA Coordinator							

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
				D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN44-5A	BOLT
2	3	3	2	AN44-6A	BOLT
2	2	2	2	AN44-7A	BOLT
1	1	1	1	AN44-14A	BOLT
	1	1		AN44-10A	BOLT
1			1	AN5-8A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

RELEASED

cap 04/05/10

DART

PPP

Part Number	D205-633-015	Box Part Number	BX105	Dimension	93"
Description	Heli-Access-Step	Other Packaging	MF166	Dimension	L x W x H MF4612C
		Logo Decals	D2728-1		N/A

Packaging Instructions and Decal Placement

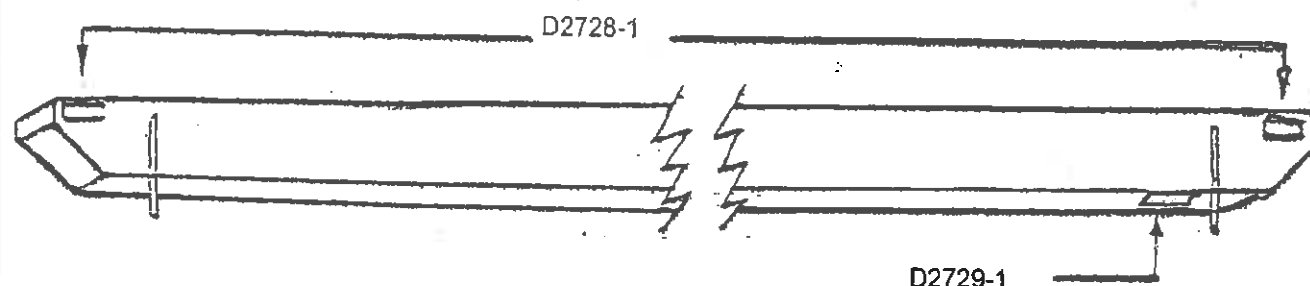
D205-633-015

Apply label D2729-1 & D2728-1 as per drawing below

Wrap step in plastic. Wrap hardware and paperwork in foam then wrap struts in foam. Tape kits on each side of step. Glue 2 pieces of MF166 one on each side. Place 3 MF4612C evenly spaced out in bottom of the box.

Insert step and put 3 MF4612C on top to correspond with bottom foams. Close the box. Apply "Dart" logo tape and strap after every second Dart logo. Place clear tape over strapping and apply label D2729-3 as per instructions in QSI 014 section 4.5.

***Shave half an inch off top foams



Bottom and Side View

D2729-1

D2729-3

DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
P/N	D205-633-015	QMS	CHG002
DESC	Heli-Access-Step	STC	SH96-57
LOT	BXXXXX	STC	SR00592/3NY
WORK	Bel 205/212/214/412	STC	SR00594NY

DART

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TEL: 1 613 632 3336 FAX: 1 613 632 4443

HELI-ACCESS-STEP

P/N: D205-633-015 CHG002

B/N: BXXXXX

Revision: C.

Date: 04.04.16

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Change Record

PAGE 1 OF 1

Part Number: D205-633-015 (DSI 9234-015)

Description: HELI-ACCESS STEP, EXTENDED HIGH GEAR (39")

[illegible]